

Work Order ID 134940

134940

Page 1

Wednesday, July 22, 2015 4:17:07 PM

Item ID: D2432

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw 19" X 24"

Start Date: 7/22/15 Start Qty: 1.00

1
1 2 ~~1~~

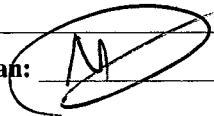
Cust Item ID:

Required Date: 7/22/15 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: 

Date: JUL 23 2015 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	H								

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

(2)  07/15/08/06

130

0.01

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.01

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

2  07/15/08/16

140

0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

2  07/15/08/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Wednesday, July 22, 2015 4:17:07 PM

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw 19" X 24"
 Start Date: 7/22/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/22/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150						2	0		QC 2015-09-16
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: st 470	0.00							
160						2			SEP 2 27 2015
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170						MCS			SEP 22 2015
QC	Memo	0.00							
Quality Control									

MCS SEP 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

Wednesday, July 22, 2015 4:17:07 PM

Page 1

Work Order ID: 134940

134940

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 7/22/15

Required Date: 7/22/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	281.5810	3.7	3.7			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

0015/08/06

Location

Loc Qty

Loc Code

MAT

225.714

m131661

43.514

m132063

182.2

MAT018

55.867

m131335

55.867

9.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
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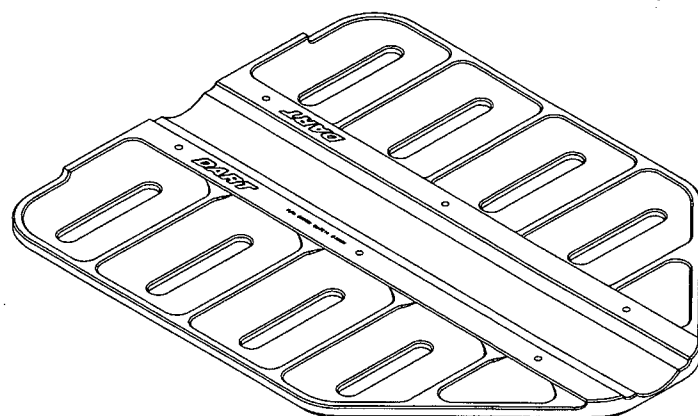
DART AEROSPACE LTD		Work Order:	134940
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

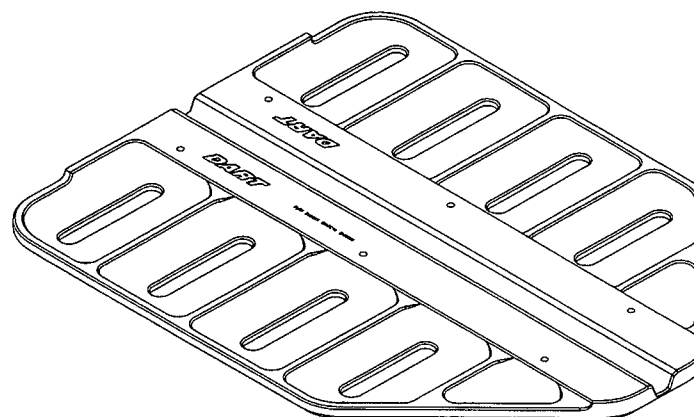
Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.053	✓		MJP-04	vern
B	0.200	+/-0.030	0.207	✓		MJP-08	Dial depth Mic
C	0.25 x 45°	+/-0.030	0.250 x 45°	✓		MJP-04	vern
D	R0.250	+/-0.030	0.250	✓		—	Radius gauge
E	0.250	+/-0.010	0.240	✓		MJP-04	vern
F	0.625	+/-0.030	0.627	✓		...	...
G	0.375	+0.030/-0.010	0.389	✓		↓	↓
H	0.950	+/-0.030	0.962	✓		↓	↓
I	19.000	+/-0.030	19.000	✓		MJP-07	Tape
J	Ø0.260	+0.005/-0.000	0.260	✓		MJP-04	vern
K	Ø0.93	+/-0.030	0.930	✓		...	...
L	0.30	+0.030/-0.000	0.315	✓		MJP-08	Dial depth Mic
M	23.750	+/-0.030	23.750	✓		MJP-07	Tape
N	2.000	+/-0.030	1.995	✓		MJP-04	vern
O	0.38	+/-0.030	0.380	✓		...	...
P							
Q							
R							
S							
T							
U							
V							

Measured by:	MJP	Audited by:	JFC	Preliminary Approval:	
Date:	15/09/16	Date:	2015-09-16	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	



D2432F BEARPAW

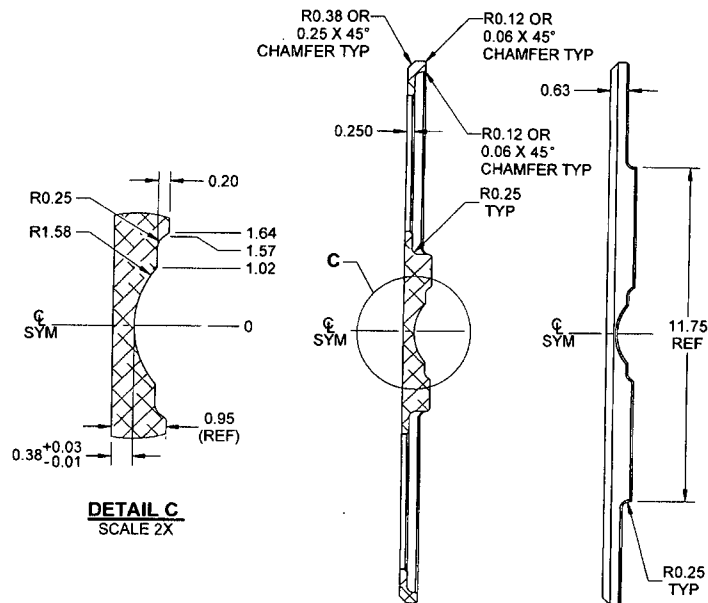


D2432-3 BEARPAW

RELEASED
2012-10-16

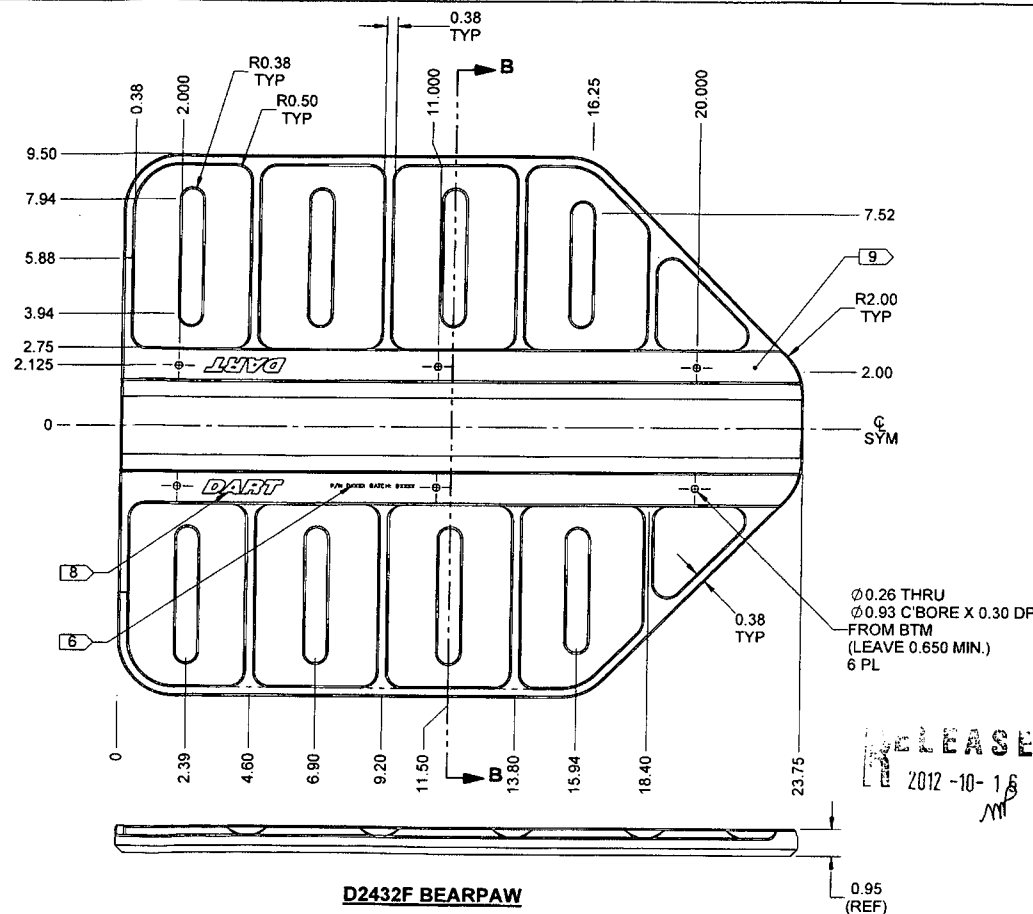
-134940 MLC
15-07-23

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	21	D2432	SHEET 1 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	21	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DETAIL C
SCALE 2X

SECTION B-B



D2432F BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 5.87 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	41	D2432	SHEET 2 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	14	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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RELEASE
2012-10-16

